

Work Order ID 82245

Tuesday, March 27, 2012 1:49:52 PM

82245Ship April 3rd Page 1

Item ID: D3400-041

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Collective Disabling Kit

Start Date: 3/27/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/2/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MEDate: 12-03-27 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3400

Rev A

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Press fit dowel pin in D3400-5
2-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.
3-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369
Identify as D3369-5

(2) FF 12-04-02

110

0.00

110

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Assemble D3400-053 as per Dwg D3400. Apply a drop of permanent locktite 262 to the threads

A/R Locktite 262 Batch: M120369
Identify as D3400-053
2-Assemble D3400-051 as per Dwg

(2) FF 12-04-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 82245***82245***

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00

120

Large Fab

Large Fab

Memo

0.00

Large Fab

Tack weld lock shaft as per Dwg D3400

A/R SS Rod Batch: M 114509EL 12-4-2 (X2)

130

0.00

130

QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

PL 12-04-032X Ø

140

0.00

140

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Sizely 03Ø

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>493</u>	0.00							
150									
Packaging	Memo <u>C420A 2p</u>	0.00							<u>JB (2) 12/04/03</u>
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							<u>12/4/3</u>
Quality Control									

12-043

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, March 27, 2012 1:49:51 PM

Page 1

Work Order ID: 82245
Parent Item: D3400-041
Parent Item Name: Collective Disabling Kit

Start Date: 3/27/2012
Start Qty: 2.00
Required Date: 4/2/2012
Required Qty: 2.00

Comments: IPP Rev:A new issue DD 10.04.15 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-028 3/16" Dowel Pin .5" long		Purchased	No			100	Each	190.0000	2	4		② FF 12-04-02	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST400		190							
				106673		98							
				108114		65							
				17848		27							
5/16WC SS Flat Washer 5/16 FW516S1		Purchased	No			100	Each	1,766.0000	2	4		② FF 12-04-02	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST377		1746							
				120262		1746							
				ST522		20							
				120208		20							
* D3369-5 Inventory		Manufactured	No			100	Each	0.0000	1	2		N.A. ② FF 12-04-02	
D3372-5 Cam Lock Shaft		Manufactured	No			100	Each	11.0000	1	2		② FF 12-04-02	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST038		11							
				76485		1							
				79039		10							
* D3373-1 Cam Lock		Manufactured	No			100	Each	50.0000	1	2		② FF 12-04-02	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST039		50							
				58463		2							
				74862		19							
				75666		29							
				B 73373-1 B 75666 FF									

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Picklist Print

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Work Order ID: 82245

Parent Item: D3400-041

Parent Item Name: Collective Disabling Kit

Start Date: 3/27/2012

Required Date: 4/2/2012

Start Qty: 2.00

Required Qty: 2.00

D3384-043 Manufactured No 100 Each 3.0000 1 2 ② FF 12-04-02
Cyclic Sock Assembly

Location Loc Qty Loc Code

ST486 3
80273 3

D3400-1 Manufactured No 100 Each 9.0000 1 2 ② FF 12-04-02
Main Body

Location Loc Qty Loc Code

st493 9
57994 9

D3400-3 Manufactured No 100 Each 0.0000 2 4 ② FF 12-04-02
Guide 8 82247

D3400-5 Manufactured No 100 Each 10.0000 1 2 ② FF 12-04-02
Slider Body

Location Loc Qty Loc Code

Mezz 10
22562 10

HX-81 Purchased No 100 Each 90.0000 1 2 ② FF 12-04-02
1/4"-20 SHCS 3/8" long

Location Loc Qty Loc Code

ST 50
120357 50
ST390 40
114383 1
120773 39

AN960-416 Purchased No 100 Each 0.0000 2 4 ② FF 12-04-02
Washer NAS1149F0463P

126739

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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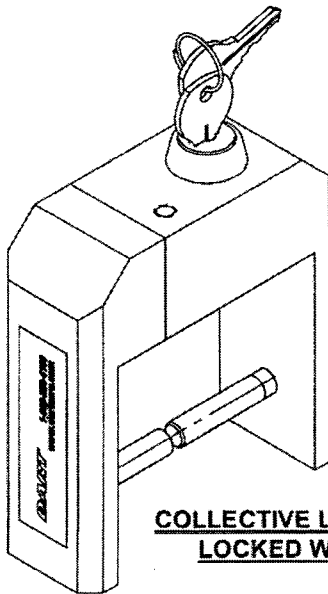
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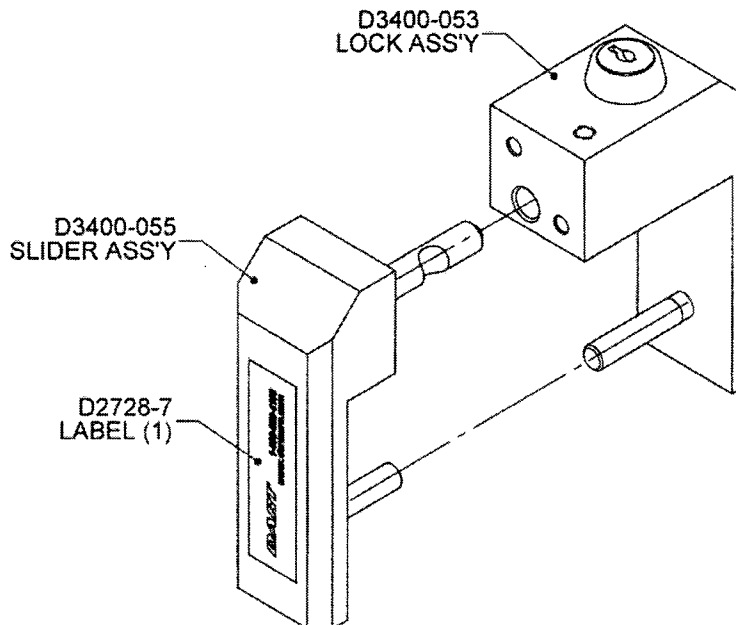
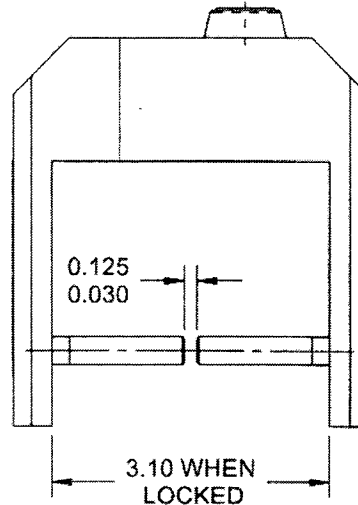


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3400	REV. A SHEET 1 OF 6
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.02.23	NEW ISSUE	

RELEASED
[Signature]
05/04/23



**COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS**



D3400-051 AS355 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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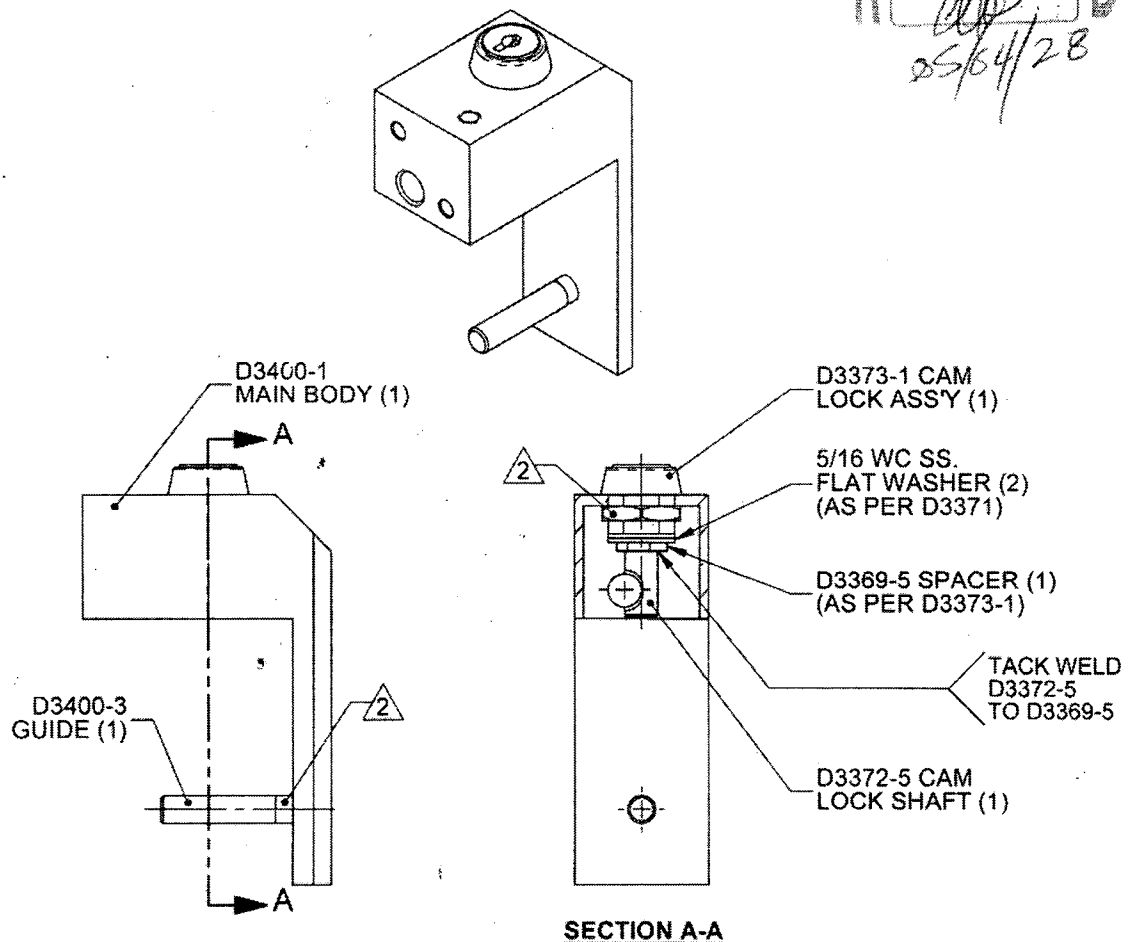
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3400	REV. A SHEET 2 OF 6
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

RELEASED
[Signature]
25/64/28



D3400-053 LOCK ASS'Y

NOTES:

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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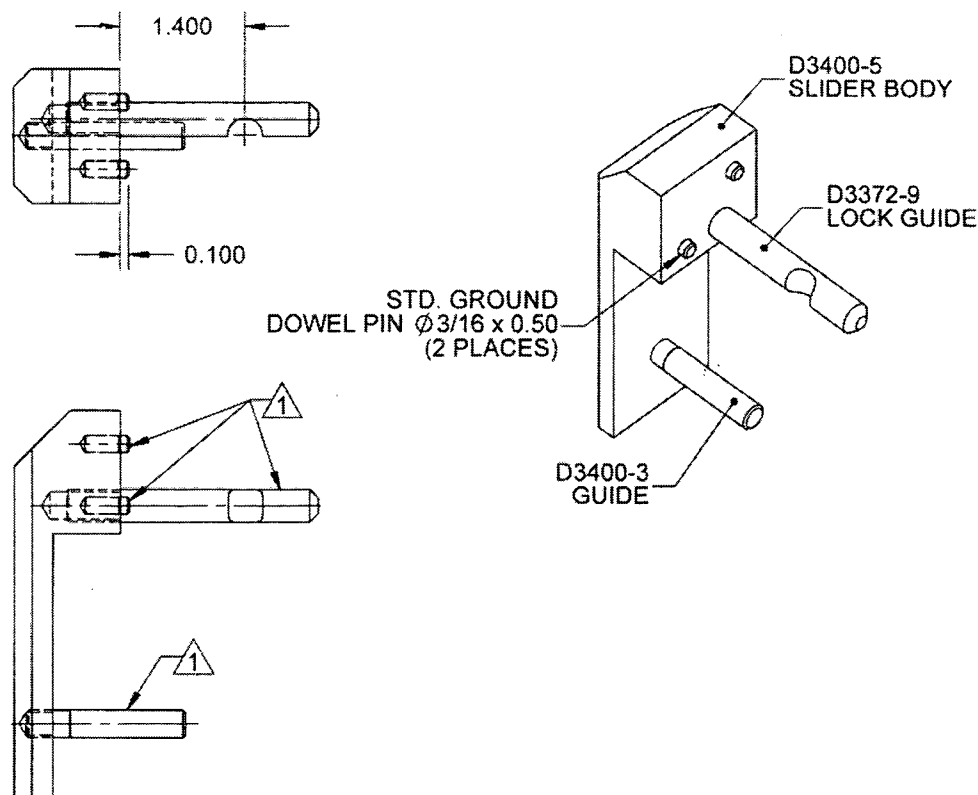
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3400	REV. A SHEET 3 OF 6
DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:2

RELEASED
[Signature]
05/04/28



#82200

D3400-055 SLIDER ASS'Y

NOTES:

- 1) COVER DOWEL PIN (2 PLACES), D3400-3 AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

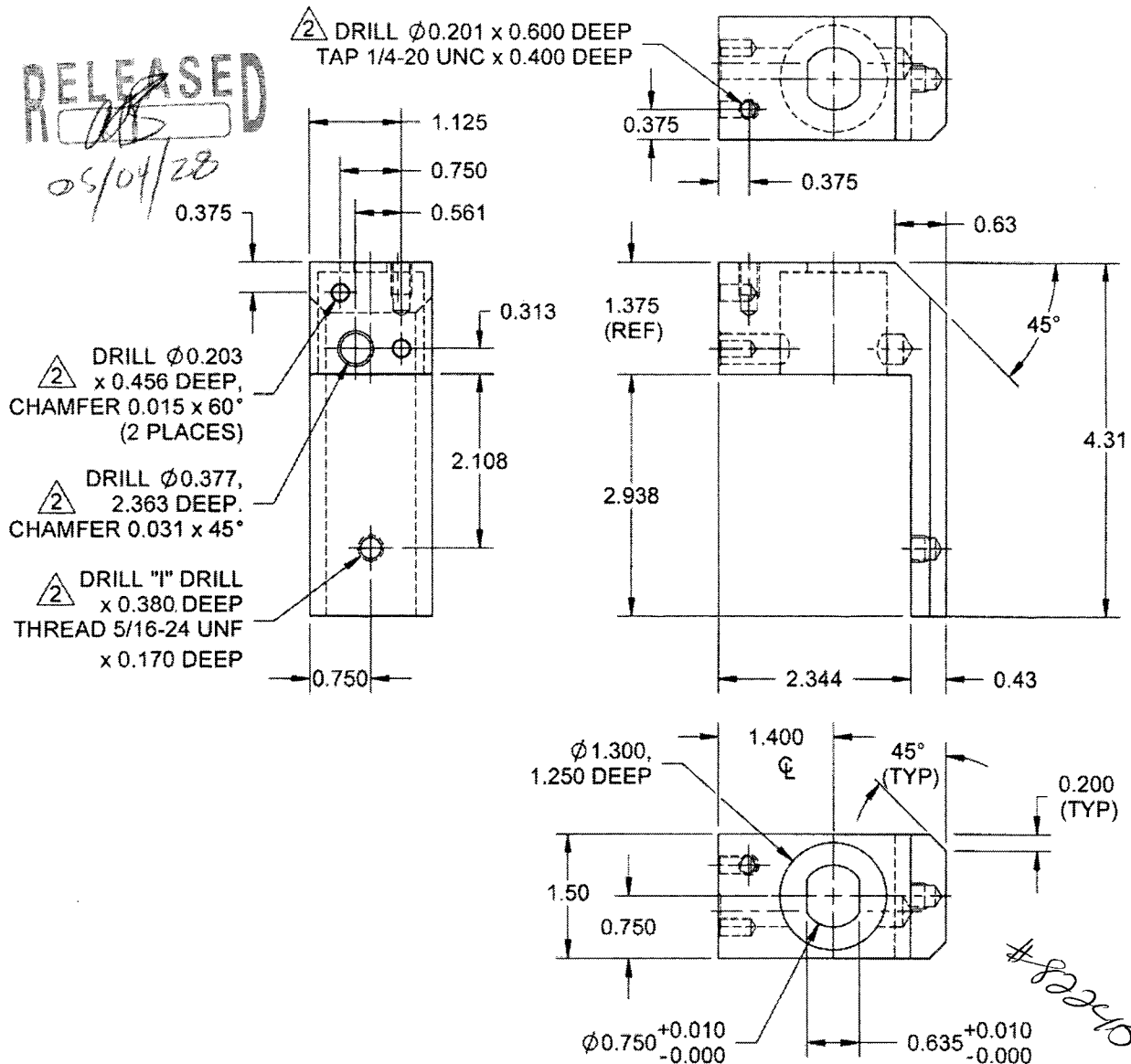
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3400	REV. A SHEET 4 OF 6
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



D3400-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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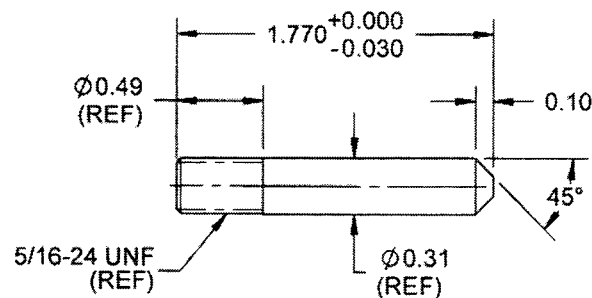
NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3400	REV. B SHEET 5 OF 6
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

SPECIFICATION CONTROL DRAWING

RELEASED
[Signature]
05/04/28



82245

D3400-3 GUIDE

NOTES:

- 1) MATERIAL: AN5-17A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

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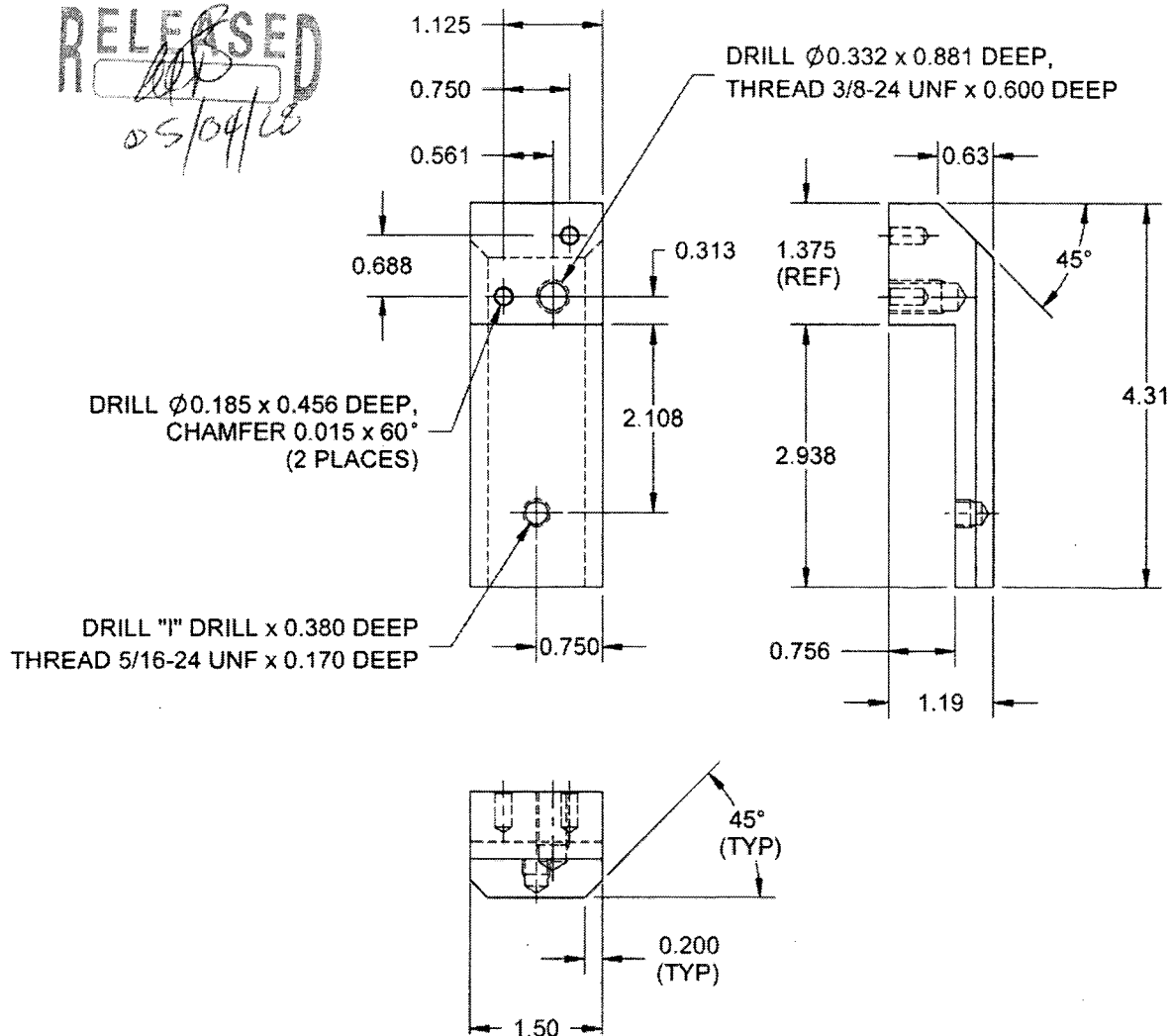
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3400	REV. A SHEET 6 OF 6
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



D3400-5 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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